



PHILARK PHILCHAMFER

Coated Electrode for Surface Preparation, Cutting and Gouging



General Description

PHILARK PHILCHAMFER is used for Non-alloyed and low alloyed steels, stainless steels, aluminium and aluminium alloys, copper and copper alloys, cast-iron and steel casts.

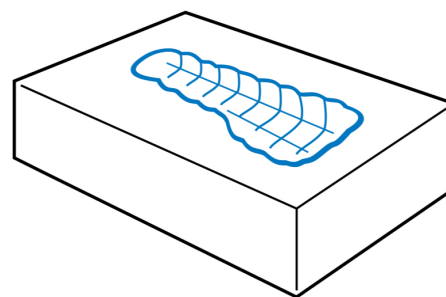
Recommended Procedure

Strike the arc with the electrode normal to the workpiece and then immediately incline the electrode at an angle of 15-20° to the workpiece. Point the arc in the direction of travel, move the electrode forward to melt the metal and then pull it back to allow the gas jet to blow the molten metal away.

Working Speed	██████████
Clean up	██████████
Heat Input	██████████

Typical Applications

- Gouging and removal of old, worn or cracked parts and correction of casting defects
- Cleaning defective surfaces and removing faulty welding deposits
- Gouging and chamfering all industry metals
- Easy striking and restriking, high gouging speed
- It burns up impurities, degasses metal, leaving it metallurgically clean



Welding Parameters

Current Type and Polarity : DC(+),
Welding Positions: Flat, Vertical, Overhead.

Diameter [mm]	3.15	4.0	5.0
Length [mm]	350	350	450
Current [A]	180-240	250-320	350-450

PHILARK ALLOYS

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